

Monday, 4/23/2007 1:48:19 PM Date User

Kim Johnston

Process Sheet

: CU-DAR001 Dart Helicopters Services Customer

Job Number : 31984

: 10058 Estimate Number

P.O. Number This Issue

: NIA : 4/23/2007

S.O. No. : NIA

Prsht Rev. : NC : MA First Issue

: PURCHASED PARTS

: 30199 Previous Run

Written By Checked & Approved By

Comment

New Issue

Drawing Name

: STEP EXTRUSION

: D2622120C Part Number : D2622 REV C1 Drawing Number

: N/A Project Number : C1 **Drawing Revision** : NIA Material

Due Date : 5/10/2007

Each

Additional Product

Job Number:



A:

Seq. #:

Machine Or Operation:

: Est.

Description:

45/101/24

1.0

PG

PURCHASING

KJ/RF



Comment: PURCHASING

Issue P/O:_ 3610

- a) Extrude as per Dwg D2622 Rev. C
- b) Material: 6061-T6 (QQ-A-200/8)
- c) Minimum yield tensile strength = 35 ksi
- d) Minimum ultimate tensile strength = 38 ksi
- e) Minimum elongation = 8%
- f) Order at 120" longg) Bon L Canada Inc. tool # 897123 Rev. A
- h) To be packed per DSK 066
- i) Pull test to ASTM standard B221 required.
- j) Material certification is required

20

D2622120CF

Extrusion





Comment: Qty.:

1.0000 Each(s)/Unit Total: 200.0000 Each(s)

Extrusion

3.0

PACKAGING 1

PACKAGING RESOURCE #1

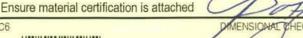








4.0 QC6







Comment: DIMENSIONAL CHECK

Inspect dimension per Dwg D2622

Check Pull test per Dwg D2622 for compliance page attached

Check hardness with Webster tester

Dart Ae	rospace	Ltd									
W/O: WORK ORDER CHANGES											
DATE	STEP	PRO	PROCEDURE CHANGE						Approval QC Inspector		
									- 62		
Part No		PAR #:	Fault Cate	egory:	NCR: Yes	DQA:	S	Date:	165/23		
					QA: N/	C Closed:		_ Date: _			
NCR:		No. of the last of	WORK ORD	ER NON-CONFORMA	NCE (NCR)			To All Sales		
DATE	CTTER	Description of NC		Corrective Action Section	POWER LAND	Verifica	tion	Approval	Approval		
DATE	STEP	Section A	Initial Action Description Chief Eng Chief Eng		Sign & Date	& Section C		Chief Eng	QC Inspector		
									1 1		

NCR:			WORK ORDI	ER NON-CONFORMANCI	= (NCR)			
		Description of NC	Corrective Action Section B				Approval	Approval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Date: User: Monday, 4/23/2007 1:48:19 PM

Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: STEP EXTRUSION

Description:

Job Number: 31984

Part Number: D2622120C

Job Number:



Seq. #:

Machine Or Operation:

5.0

PACKAGING 1

PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE



Job Completion



10765-2 10765/23 U Strus 23

Dart Aerospace Ltd

A Check Section									
W/O:			WO	RK ORDER CHANG	ES				
DATE	STEP	PRO	PROCEDURE CHANGE						Approval QC Inspector
Part No:		PAR #:	Fault Categ	ory:	NCR: Yes	No DQ	A:	_ Date: _	1 21
填									
NCR:			WORK ORDE	R NON-CONFORMA	ANCE (NC	R)			
DATE	STEP	Description of NC	Corrective Action Section B			Verific	ation	on Approval	Approval
DATE	aler	Section A	Initial Chief Eng	Action Description Chief Eng	scription Sign & Date			Chief Eng	QC Inspector

NOTE: Date & in tial all entries





DESIG	KE	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHEC	KED W	APPROVED	DRAWING NO. REV. C
	#	of the second	D2622 SHEET 1 OF 1
DATE			TITLE SCALE
02.	09.11		STEP EXTRUSION 1:1
Α		96.11.29	NEW ISSUE
В		97.12.12	CHANGE MATERIAL, ADD TOL. QSI
C		02.09.11	0.080 WAS 0.085; ADD PART & DIE No.
CI	# 11	02.10.04	ADD 'REV. A' TO DIE NUMBER

		CI I ALL	02.10.04	nu kt	Y.A TO	LIE WAY
	-	3.000 -		-		
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0.958			_	-	0.080	
2.500	-	Î				
2,500				A R	2.085	
	60.4			/	0.248	(REF)
	(REF)	l ç		→ R0.5	85	
	-	- 1.193 - - 1.874 (RE		10.5	00	

D2622-XXX STEP EXTRUSION

- 1) PART NUMBER IS D2622-XXX WHERE 'XXX' IS CUT LENGTH IN INCHES (EG. D2622-120 IS 120" LONG)
- 2) MATERIAL 6061-T6 (QQ-A-200/8)
- 3) MANUFACTURED USING BON-L DIE # 897123 REV. A

4) A SAMPLE FROM EACH BATCH WILL BE PULL TESTED TO ASTM STANDARD B221 BY AN APPROVED TESTING FACILITY TO ENSURE THAT THE BATCH MEETS THE MINIMUM MECHANICAL PROPERTIES STATED BELOW:

MINIMUM TENSILE YIELD STRENGTH = 35 ksi MINIMUM ULTIMATE TENSILE STRENGTH = 38 ksi MINIMUM ELONGATION = 8%

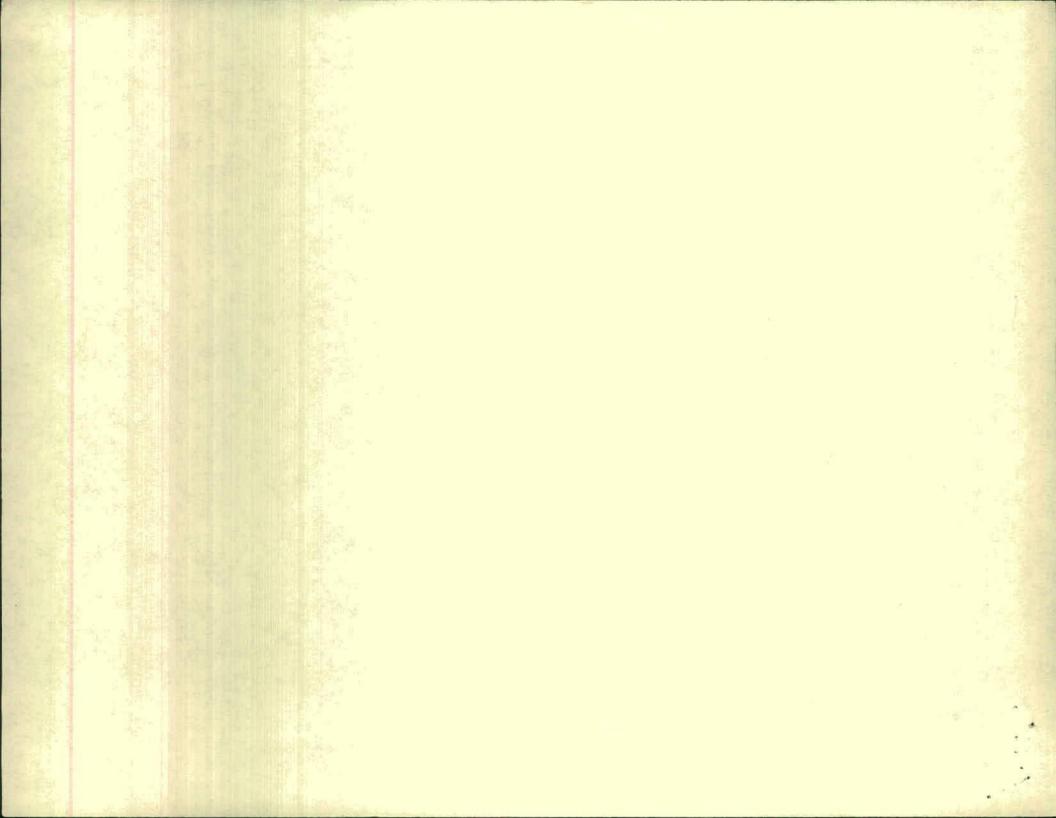
- 5) PART IS SYMMETRIC ABOUT CENTERLINE
- 6) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 7) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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SHOP COPY RETURN TO ENGINEERING

UNCONTROLLED COP



N L CANADA INC.

INVOICING COMPANY AND LOCATION BUREAU DE FACTURATION

SHIPPING MANIFEST BORDEREAU D'EXPEDITION

MANIFEST DATE/DATE D'EXPÉDITION

THE WILLIAM L. BONNELL COMPANY, INC.
BON L MANUFACTURING COMPANY SUBSIDIARIES OF THEDEGAR CORPORATION FILIALES OF LA CORPORATION TREDEGAR



BON L CANADA INC 500 EDWARD AVENUE RICHMOND HIL ON

LOC/USINE

RIH

L4C 4Y9

SALESMAN/VENDEUR

59358

REFER TO THESE NUMBERS ON ALL CORRESPONDENCE. RÉFÉREZ-VOUS À CES NUMÉROS POUR TOUTE

MANTEST NUMBERIN' D'EXPÉDITION

SALES ORDER NUMBER/N° DE COMM.

EROSPACE LTD. BERDEEN ST. BURY

SOLD TO/VENDU À

DART AEROSPACE LTD. 1270 ABERDEEN ST. HAWKESBURY

PHONE 613-632-5200

MEG PART AUMPER

OM K6A 1K7 CN

**** *0/P* ****

TRAILER NO /N° DE REMORQUE

BILL OF LADING NUMBER/N° DE CONNAISSEMENT

CREDIT REP REP. DU CRÉDIT HAMBROOK, PAU

CORRESPONDANCE.

SALES REP REP. DES VENTES

905-508-3250

FIELD SALES REP REP. RÉGIONAL DES VENTES

Kutter A 450-435-6551

CUST SERVICE REP REP. SERVICE CLIENTÈLE Burton D

905-427-2227

613-632-5200

ORDER DATE DATE DE LA COMMANDE JU CLIENT

ER QUAN

04/24/07

3610

CUST. P.O. NO./N° DE COMM. DU CLIENT

00343023

ANTITY	UNIT	PREVIOUS SHIPPED QTY. QTÉ DÉJA EXPÉDIÉE	N° DE PIÈCE DU FOURNISSEUR CUSTOMER PART NUMBER	ALLIAGE & TREMPE LENGTH LONGUEUR	FINISH DESCRIPTION DESC, DE LA FINITION FABRICATION DESCRIPTION TYPE DE FABRICATION	SEMEST AND ASSESSED.	IIS SHIPMENT/CETTE	EXPÉDITION	UNIT	OLIANTITY DUE
ng Sweet	VC	of the same track from	NUMERO DE PIÈCE DU CLIENT	CUTTING TOLERANCE TOLERANCE DE COUPE	SHIPPING TOLERANCE TOLERANCE D'EXPEDITION	NO. PKGS. N° DE PAQUETS	GROSS WT. POIDS BRUT	NET WT. POIDS NET	UNITE	QUANTITY DUE QUANTITÉ PRÉVUE
200	KG M PC		DAA-897123-1 D2622	A CONTRACTOR OF THE PARTY OF TH	MILL CERTIFICATE OF COMP (+015-015,0230-0170)	3	915	888 640 210	KG M PC	0 0 0
			DETAIL; LOT/TIC		67821010 / 168050 67821010 / 168051 67821010 / 168053	1 1 1	305 305 305	296 296 296		70 PC 70 PC 70 PC
				1/03	108		785			

ERIALS WILL BE ACCEPTED FOR CREDIT WITHOUT PERMISSION DE MATÉRIEL NE SERA ACCEPTÉ POUR CRÉDIT SANS AUTORISATION

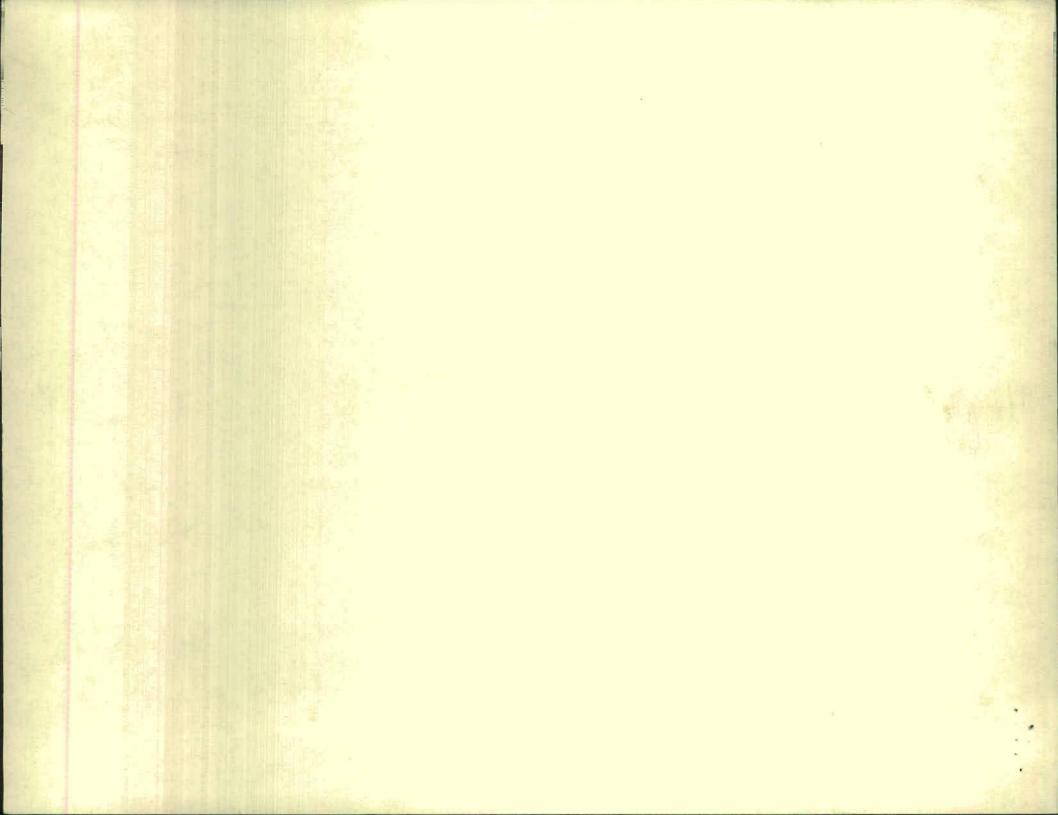
IN EDGEMENT OF COORS DELINEARS AND OF

CUSTOMER CLIENTAGE

888 K,G640 TOTALS/TOTAUX

(AGENT MUST DETACH AND RETAIN THIS SHIPPING ORDER AND MOST SIGN THE ORIGINAL BILL OF LADING - EXPRESS SHIPPING CONTRACT) (CET ORDRE D'EXPÉDITION DOIT ÉTRE DÉTACHÉ ET CONSERVÉ PAR L'AGENT, L'EQUEL DOIT SIGNER LE CONNAISSEMENT ORIGINAL " RÉCÉPI SHIPPING ORDER ORDER ORDER

ISSÉ DE MARCHANDISES PAR RAIL EXPRESS)



500 EDWARD AVENUE RICHMOND HILL, ON L4C 4Y9

05/07/07	159080	67821	. 1
Cust PO	B/L No	Lot	Date
3610	00343023	67821010	5/07/07

Sold To 46024

DART AEROSPACE LTD.

1270 ABERDEEN ST. HAWKESBURY, ON K6A 1K7 DART AEROSPACE LTD.
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7

Part No	Item Description		Cust Part
DAA-897123-1	120" Mill 6061 T6		D2622
915 K	GS		
888 KG	210 PC	640 M	3 PKG
	915 KG	DAA-897123-1 120" Mill 6061 T6 915 KGS	DAA-897123-1 120" Mill 6061 T6 915 KGS

AMS-QQ-A-200/8 & ASTM B221-00

Mecha	nical	Tests:										
Test	Te	nsile		Y	ield						Bend/	
No.	MPA	/ KSI		MPA	/ KSI	21	Elonga a	tion	Conduc	tivity	Drift	HREW
			,									• • • •
1	326.2	/ 47.	3	288.3	/ 41.8	~		10.9 -		.0		93
2	318.7	/ 46.			/ 40.9			10.5	/	.0		93
Chemi	cal An	alysis	:									
SI	FE	CU	MN	MG	CR	ZN	TI					

.67 .25 .24 .06 .90 .06 .06 .02

This will certify that the material described herein has been inspected and tested in accordance with Bon L Canada's standard sampling and testing procedures or in accordance with the requirements of any specifications forming a part of the material description to the extent indicated herein. Data of chemical composition for the material and test results from samples representative of the material are set forth above hereof or in any attachments hereto. This information shows that the material meets the applicable requirements. Inspection and test records are maintained on file. This certificate shall be deemed apart of and subject to the terms and conditions of warranty set forth on the reverse side of our order acknowledgement form. No other warranties are applicable.

D. VanBakel, QA Manager Signed for Bon L Canada

